

Date: Friday, 5/25/2007 8:36:41 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM	POSITIVE RECALL
Job Number : 32645		EFFECTIVE 07.06.05 AUTH <i>JP</i>
Estimate Number : 12882		RELEASED 07.06.06 DATE <i>JP</i>
P.O. Number : <i>NA</i>	Part Number : D3560042	
This Issue : 5/25/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3560 REV.B	
Prsht Rev. : NC	Project Number : N/A	
First Issue : <i>NA</i>	Drawing Revision : B	
Previous Run : <i>NA</i>	Material : <i>NA</i>	
Written By : <i>JP</i>	Due Date : 6/5/2007	Qty: 30 Um: Each
Checked & Approved By : <i>JP 07.05.25</i>		
Comment : Est Rev: A New Issue 07.05.24 EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.4648 f(s)/Unit Total: 43.9425 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: *17625X10**M 104598 X 20 pcs**J.F. / BG**07.06.01*

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 16.750" long

*J.F. / BG**07.06.01*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA694 Rev: *AA* & Dwg D3560 Rev: *B*2-C'sink 0.196" hole on manual mill as per dwg D3560 *SAD 07/06/28*

3-Deburr per dwg D3560

*J.F. / BG**07.06.01*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.F. / BG**BG 07.06.01*

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*J.F. 07/06/12**Split (19)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.06.06	11	NO POWDER COAT. CHEM. CONV. COAT ONLY. REF ATTACHED DS EMAIL				CP 07.06.06 P.L. QSI 042	2 07.06.07	
07.06.28	2A	D2808 Bracket <u>1x 28600 / 4x 32752</u> Put Bush	JE	07.06.27	6	U 2808-16		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA ☒ Date: 07/07/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.06.06	3	Qty(1) C-Bore $\phi 0.510$ INSTEAD OF $\phi 0.507$	CP 07.06.06 PW QSI 042	SCRAP/REPLACE	J.F. 07/06/27	2 07.06.27	CP 07.06.06 PW QSI 042	2 07.06.27

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32645

Part Number: D3560042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)
PLATE *3 32461*

SE 07-06-26

6

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

Well Rod B 104305

SE 07-06-27

6

8.0

QC5

INSPECT WORK TO CURRENT STEP



En 07-06-28

SE 07-06-27



Comment: INSPECT WORK TO CURRENT STEP

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AD 07-06-28

(6)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AM 07-06-28

6

11.0

POWDER COATING

POWDER COATING



*NO POWDER COAT
SEE WLD CHANGE*



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SE 07-06-28

6

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LWA*

SE 07-06-28

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/07/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:36:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32645

Part Number: D3560042

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



6

Comment: FINAL INSPECTION/W/O RELEASE

Handwritten signature

Job Completion



Handwritten signature

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE *5/25/07*

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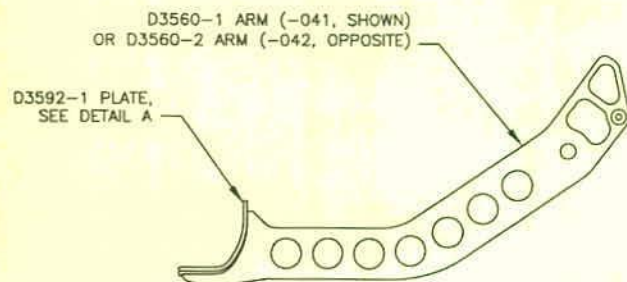
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

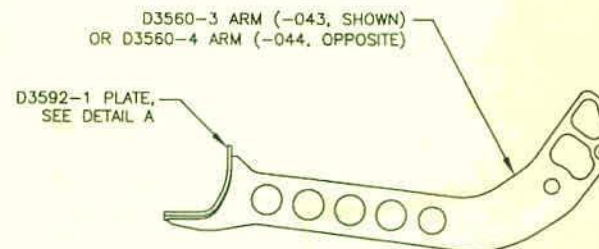
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

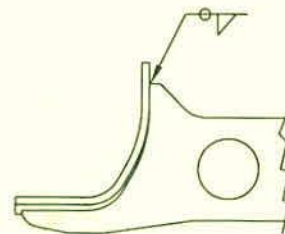
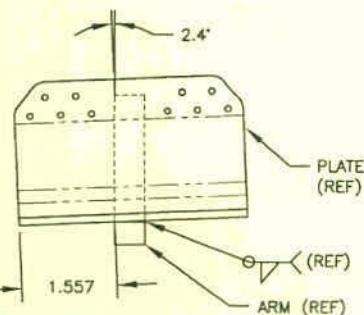
NOTE: Date & initial all entries



**D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)**



**D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)**



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 004 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

07.05.07

B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	qf	DRAWN BY qf
CHECKED	qf	APPROVED
DATE	07.01.15	TITLE
		ARM WELDMENT
		REVISION
		REV. B
		SHEET 1 OF 3
		SCALE
		1:4

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DART DART AEROSPACE LTD.
WINDSOR, ONTARIO, CANADA

DRAWING NO. D3560

TITLE

ARM WELDMENT

SCALE

1:4

WORK ORDER
32645

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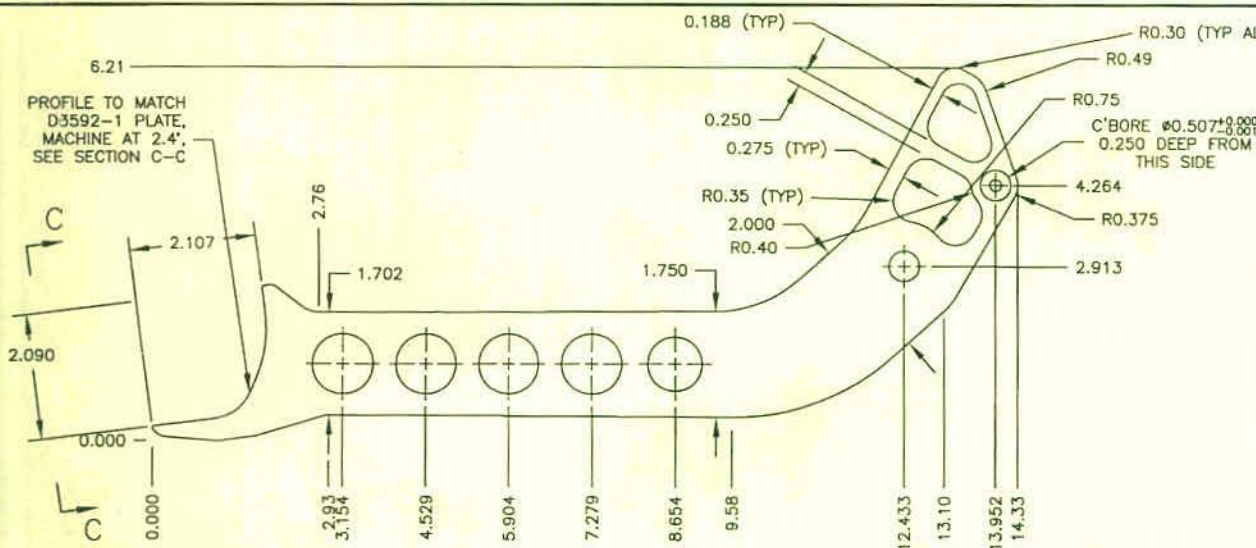
07.05.07 H

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SCALE

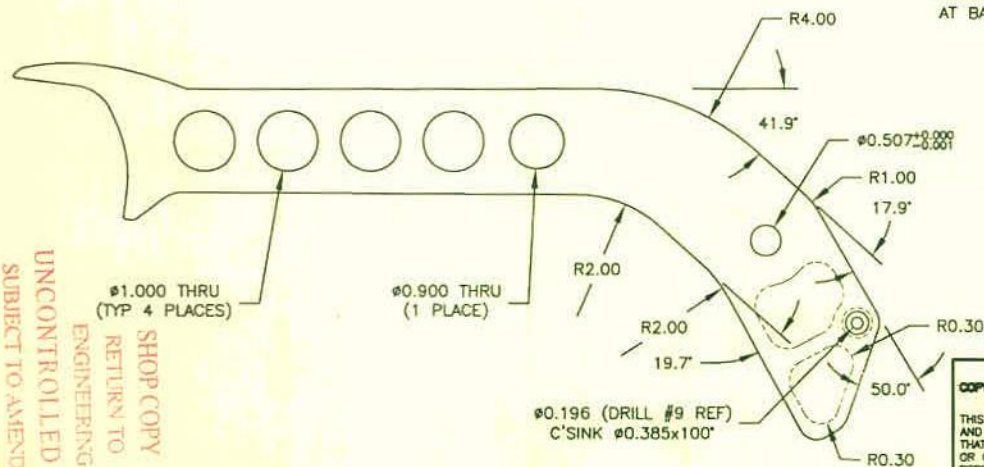
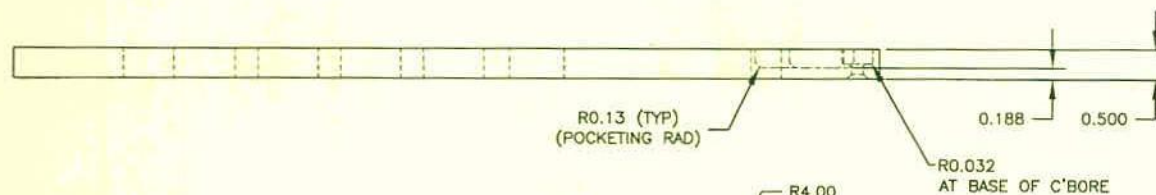
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WORK ORDER
NO. 32645

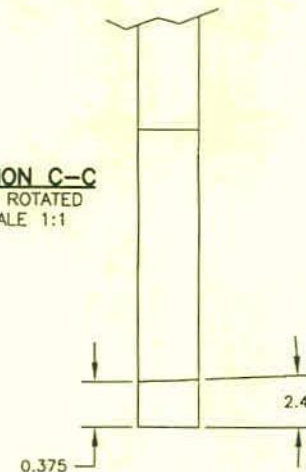


D3560-3 ARM (SHOWN). D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C VIEW ROTATED SCALE 1:1



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NO. 32645

WORK ORDER

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DESIGN	40	DRAWN BY	40	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	40	APPROVED	40	DRAWING NO.	D3560
DATE	07.01.15	TITLE	ARM WELDMENT	REV. B1	SHEET 3 OF 3
				SCALE	1:2

DART AEROSPACE LTD		Work Order: 32645
Description: Cross Tube Assembly <u>ARTM</u>		Part Number: 3560-2
Inspection Dwg: 23560	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	14.73	± 0.03	14.73	✓		
	$\phi .507$	± 0.000 -0.001	.507	✓		
	.250	± 0.01	.250	✓		
	.188	"	.188	✓		
	.250	"	.250	✓		
	.275	"	.275	✓		
	2.465	"	2.465	✓		
	12.682	"	12.682	✓		
	14.73	± 0.03	14.73	✓		
	4.481	± 0.010	4.481	✓		
	5.633	"	5.633	✓		
	.188	"	.188	✓		
	12.032	"	12.032	✓		
	.500	"	.500	✓		
	.507	± 0.000 -0.002	.507	✓		
	$\phi .196$	± 0.005 -0.001	.196	✓		
SIDE B	.385 X 100°	± 0.010	.385	✓		
	$\phi 1.000$	± 0.010	1.000	✓		
	2.000	"	2.000	✓		
	1.000	"	1.000	✓		
	.375	± 0.010	.375	✓		
	12.134	± 0.03	12.13	✓		
	.850	± 0.01	.850	✓		

Measured by: <u>361</u>	Audited by: <u>3L</u>	Prototype Approval: <u>JP</u> N/A
Date: 07-06-01	Date: 07/06/01	Date: 07.06.01 N/A
Rev A	Date	Change New Issue
		Revised by KJ/JLM
		Approved

100

100

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 5, 2007 5:18 PM
To: 'Chris Provencal'
Subject: RE: D3562-041/-042

As we have discussed previously, this is acceptable as long as the Magnabond doesn't break down.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, June 05, 2007 11:00 AM
To: David Shepherd (David Shepherd)
Subject: D3562-041/-042

David,

For the D3562-041/-042 step weldment, as discussed. They want to switch from Sikaflex to Magnabond, and powder coat after final assembly.

As part of this change, the D3560-XX arms won't be powder coated, and the D2808 Bushing won't be assembled until after final assembly of the step weldment.

Since this is the first time trying this, we will ensure that the steps are checked after powdercoating in case the Magnabond doesn't do anything unexpected (eg. bubbling). If we see anything suspect, we will assemble them the old way.

Is this acceptable.

-Chris

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Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

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